

Date: Wednesday, 15/08/2007 4:04:30 PM
 User: Linda Lacelle

Process Sheet

| | | | |
|-----------------------|---|------------------|-----------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : "T" HANDLE ASSEMBLY |
| Job Number | : 33958A | Part Number | : D2282041 |
| Estimate Number | : 11179 | Drawing Number | : D2282 REV E |
| P.C. Number | : N/A | Project Number | : N/A |
| This Issue | : 15/08/2007 S.O. No. : N/A | Drawing Revision | : E |
| Prsht Rev. | : NC | Material | : N/A |
| First Issue | : N/A Type : SMALL /MED FAB | Due Date | : 22/09/2007 |
| Previous Run | : 33831 | Qty: | 100 Um: Each |
| Written By | : <u>W</u> | | |
| Checked & Approved By | : <u>W</u> | | |
| Comment | : Est Rev:A Removed from 9 Digit 05-12-02 JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|--------|------|
| 1.0 | D22823 | Tube |
|-----|--------|------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2282-3

Handle tube

b33415 ←

b33259 ←

26x

84x

110x

sd 07/09/27

| | | |
|-----|--------|------|
| 2.0 | D22825 | Tube |
|-----|--------|------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2282-5

Handle tube

B34182

110x

sd 07/09/27

| | | |
|-----|-------------|------------------------------|
| 3.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per D2282-041 'T' Handle Assembly

Grind chamfers and ensure full penetration.

A/R ER316L SS

Filling Rod

*M102421*Dwg Rev: *E*

PD 07-10-02 *115*

W/O:

WORK ORDER CHANGES

| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
|------|------|------------------|----|------|-----|-------------------------------------|--------------------------|
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/10/11
 QA: N/C Closed: _____ Date: _____

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
|------|------|--------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:04:30 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: "T" HANDLE ASSEMBLY

Job Number: 33958A

Part Number: D2282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

DO NOT USE

WELD INSPECTION



Comment: WELD INSPECTION

QC9 11/07/02
QC5 07/10/02



110

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1



counted

Tumble

SAD 07-10-04

110

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



07/10/05

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1



Identify and Stock

Location: GA

SB 07/10/08 110

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



07/10/11

Job Completion



U 07-10-09

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

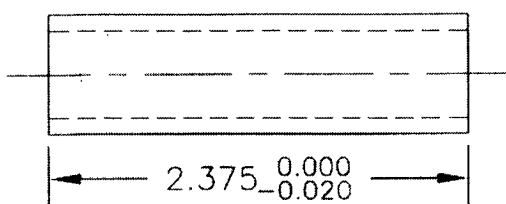
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

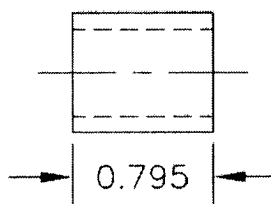
NOTE: Date & initial all entries



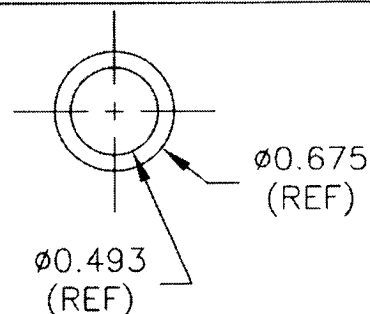
| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN BW | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2282 | REV. E SHEET 1 OF 2 |
| DATE 05.06.07 | TITLE HANDLE TUBES | | SCALE 1:1 |
| A | 94.10.14 | NEW ISSUE | |
| B | 95.03.23 | RE-DESIGN | |
| C | 97.10.20 | CORRECTED NUMBERING SCHEME | |
| D | 05.03.16 | REDESIGN D2282-5; 0.795 WAS 0.750 | |
| E | 05.06.07 | D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030 | |



D2282-3

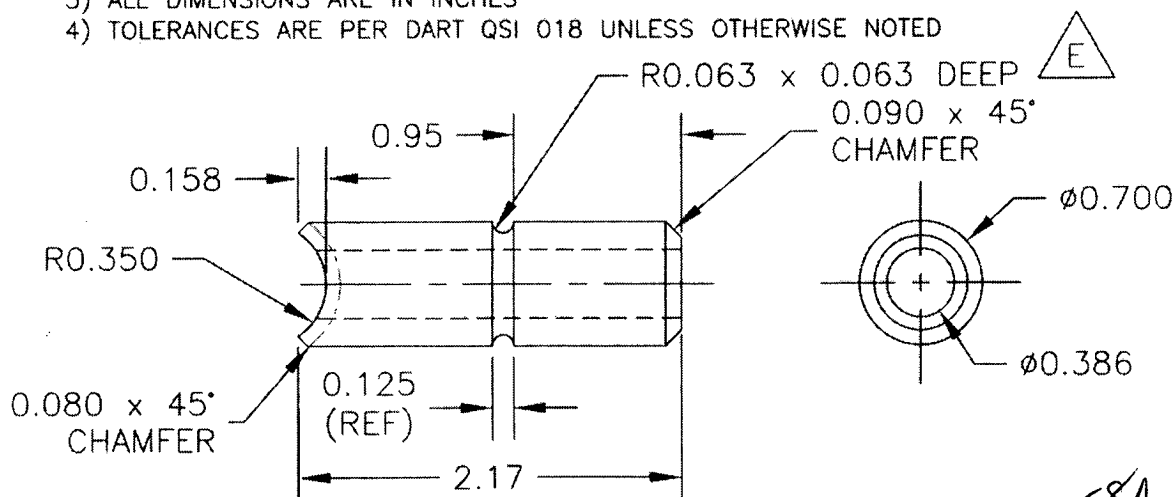


D2282-7



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5

Mo 339584

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

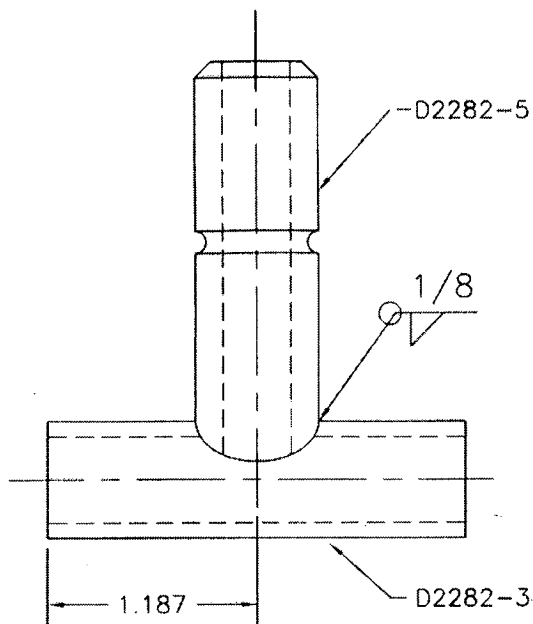


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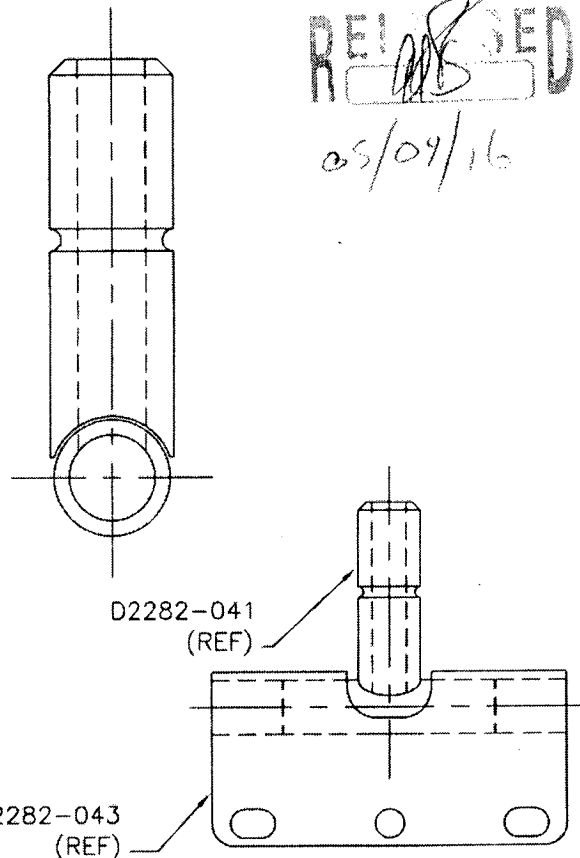
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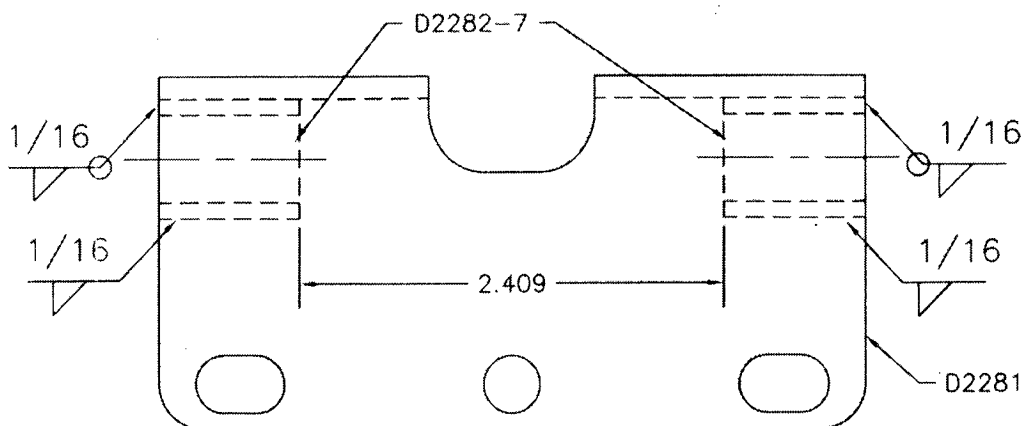
| | | | |
|----------------------|--------------------------------|---|------------------------|
| DESIGN BW | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>UP</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2282 | REV. E SHEET 2 OF 2 |
| DATE 05.06.07 | TITLE HANDLE TUBES | | SCALE 1:1 |



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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